

Work Order ID 52696

October 8, 2009 7:23:43 AM



Page 1

Item ID: D3282-041
Revision ID: C
Item Name: Float Web (206L/407)

Accept



Setup Start



Stop



Start Date: 10/08/09 Start Qty: 12.00
Required Date: 10/16/09 Req'd Qty: 12.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *V*
QC:

Date:
Date:

Tooling:

SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3282	Rev C

100



Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3282.
per QS10018

12- inspect for surface damage as

(12x)

MB 09-10-08

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA579 & Dwg D3282: 12-Debur

H.A 09/10/21
DJT 09/10/22

12 1 2

PTO →

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

H.A 09/10/21
DJT 09/10/22

12 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3282-041 PAR #: N/A Fault Category: Machine NCR: Yes No DQA: ls Date: 09-11-06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ls Date: 09-11-07

NCR: 52696		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/10/21	110	→ 17 (.500" holes) are offset by .250" on X axis. cc: operator error (bad origin) → Some holes (.500") are excentric (oval by .030")	<i>[Signature]</i>	origin has been fixed and gage blocks (x3) have been machined in the center to solve the problem of (oval holes)	H.A 09/10/21	<i>[Signature]</i> 09/10/22	<i>[Signature]</i>	09-10-23
		deviation of the drill due to previously drilled holes in gage blocks (x3) → 1 part scrap	<i>[Signature]</i>	SCRAP PART. HOLES WILL CONFLICT WITH X-BOLT SPACERS replaced 09.10.22		<i>[Signature]</i>	<i>[Signature]</i>	09-10-23
		100% R.C. Process.						

NOTE: Date & initial all entries

Work Order ID 52696

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Setup Start



Stop



Start Date: 10/08/09 Start Qty: 12.00
Required Date: 10/16/09 Req'd Qty: 12.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

ant 09/10/25

12

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

M-h 09/10/26

12x

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

all 09/10/26

12

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52696

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Page 3

Item ID: D3282-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Float Web (206L/407)

Start Date: 10/08/09 Start Qty: 12.00



Cust Item ID:

Required Date: 10/16/09 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web A/RN/ALPS-3 M 17395

12

M 9/10/28

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 509/10/09

(A2) /

180



Packaging

Packaging

Identify as per dwg & Stock Location: LG.

0.00

Memo

0.00

12

M 9/10/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52696

October 8, 2009 7:23:44 AM



Page 4

Item ID: D3282-041
Revision ID: C
Item Name: Float Web (206L/407)

Accept



Setup Start



Stop



Start Date: 10/08/09 Start Qty: 12.00



Cust Item ID:

Required Date: 10/16/09 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/10/30 HJ

MF

09-10-29

Picklist Print

October 8, 2009 7:23:42 AM

Page 1

Work Order ID: 52696

Parent Item: D3282-041RevC

Parent Item Name: Float Web (206L/407)


Comments:

Start Date: 10/08/09

Required Date: 10/16/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2792-130RevA1		Manufactured	No			160	Each	40.0000	12.0000			
 EXTRUSION												

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
42366

40
40

D3283-1RevE Manufactured No



Doubler

160 Each 20.0000 24.0000



(12x) MB 09-10-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
48423

B52904
20
20

MS20470AD4-7 Purchased No



Rivet, Universal Head

100 Each 3,771.000 684.0000



4
20
M 9/10/28

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
110731
112492

3771
1171
2600

689
M 9/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 52196
Description: Float Web		Part Number: D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

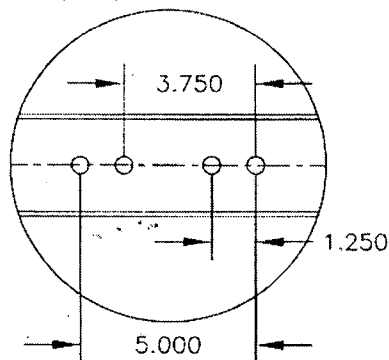
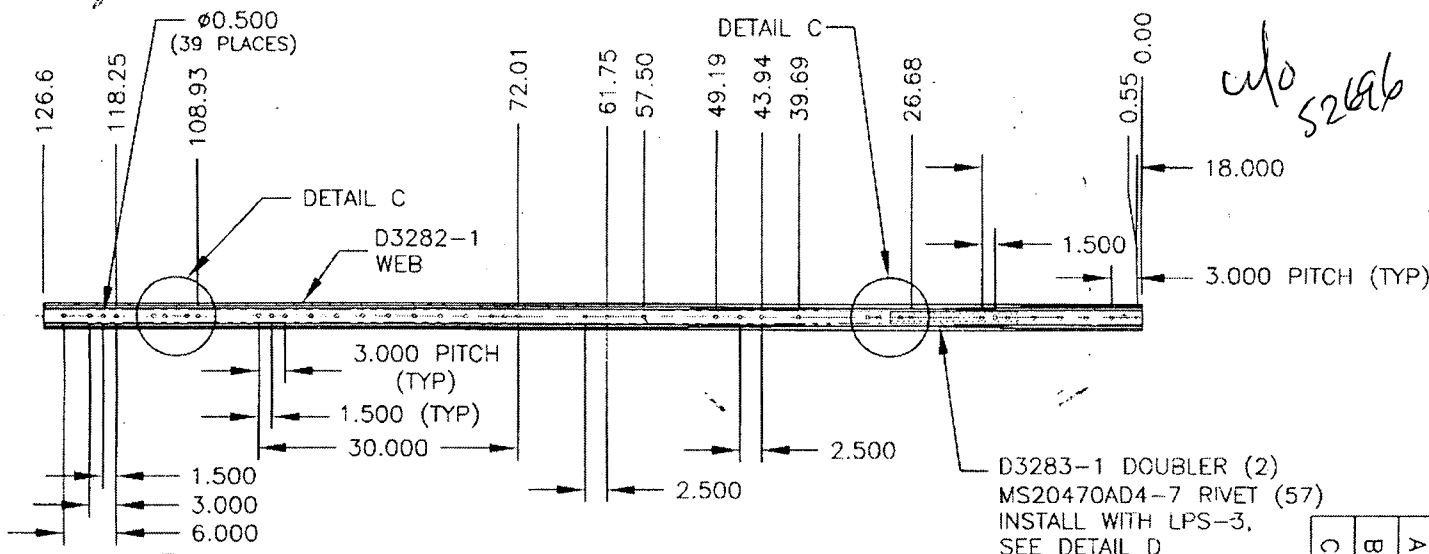
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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1.500	+/-0.010	1.500	✓			
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	6.000	✓			
1.250	+/-0.010	1.250	✓			
30.000	+/-0.010	30.000	✓			
1.500	+/-0.010	1.500	✓			
72.01	+/-0.030	72.01	✓			
61.75	+/-0.030	61.75	✓			
57.50	+/-0.030	57.50	✓			
49.19	+/-0.030	49.19	✓			
43.94	+/-0.030	43.94	✓			
39.69	+/-0.030	39.69	✓			
26.68	+/-0.030	26.68	✓			
0.55	+/-0.030	0.550	✓			
1.970	+/-0.010	1.970	✓			
2.38	+/-0.030	2.373	✓			
0.05	+/-0.030	0.052	✓			

Measured by: H.A. / DJP	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/10/21	Date: 09/10/25	Date: N/A

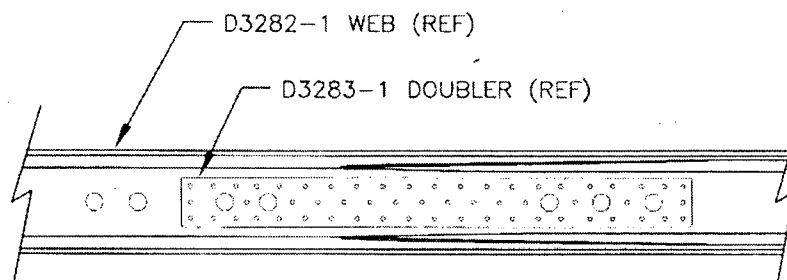
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM [Signature]	[Signature]

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CP	CP	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
#	#	D3282	SHEET 1 OF 2
DATE		TITLE	SCALE
05.08.09		FLOAT WEB, 206L/407	1:20
A	04.05.05	NEW ISSUE	
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS	
C	05.08.09	REMOVE D3390-1, NOW MACHINED	



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

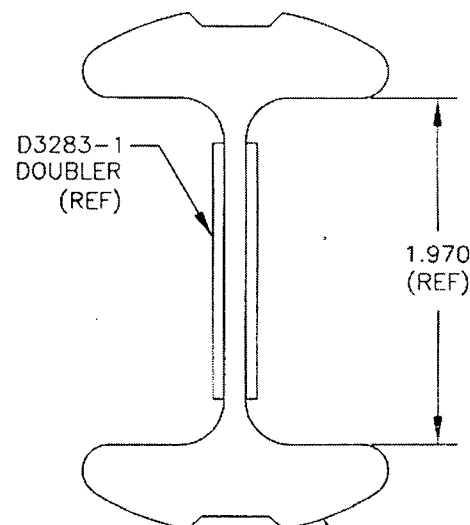
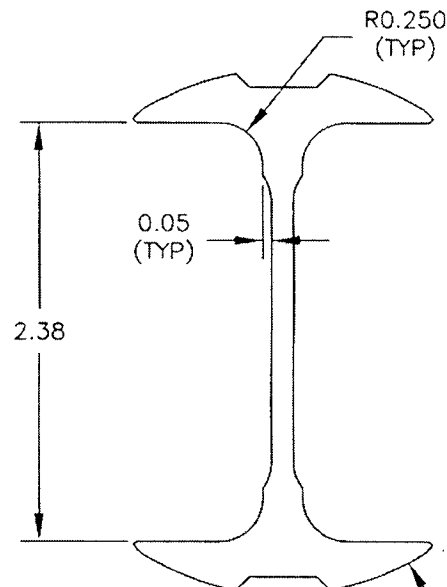
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RELEASED
08-09-12

who
52696

SECTION B-B

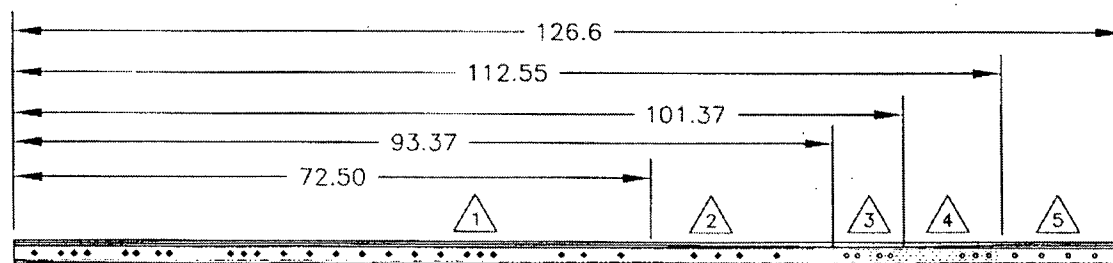


D2792-130
EXTRUSION
(REF)



- D2792-130
EXTRUSION
(REF)

D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A (REF)
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



05-04-12

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. C
				D3282	SHEET 2 OF 2
DATE	TITLE			SCALE	
05.08.09	FLOAT WEB, 206L/407			1:20	

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